



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V1001101-PO
Job Sheet 182230



Part No: RBEM632V1001101-PO

Job Qty: 1 ea

Part Name: Main Gear Box Sling



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 10/22/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBEM632V1001101 Rev. 2 IPP Rev. B 18.08.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		10/22/18	0.00	0.00	Purchasing		NOV 02 2018
110	Packaging	1 pcs		10/22/18	0.00	0.00	Packaging2		NOV 02 2018
120	QC	1 pcs		10/22/18	0.00	0.00	QC6		38
130	Small Fab	1 pcs		10/22/18	0.00	0.50	Small Fab-4		MU 9-88 DAS
140	QC	1 pcs		10/22/18	0.00	0.00	QC5	DAS	38
150	Packaging	1 pcs		10/22/18	0.00	0.00	Packaging3-1	69	NOV 09 2018
160	QC21-FG	1 Ea		10/22/18	0.00	0.00	QC21	9-89	21 NOV 09 2018

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 090784 MANUFACTURE RBEM632V1001101 AS PER Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2- Attach placard RB41011 to Starpoint VRS with lanyard and ferrules as per DWG 3- Assemble as per DWG

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM632V1001101P	Main Gear Box Sling	1 Ea (1 ea)	100-Purchasing	S124023
0502658	Starpoint VRS w/Star Key	1 Ea (1 ea)	130-Small Fab	S0501658
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	130-Small Fab	S122137
91455A140	Flat Washer	7 Ea (7 ea)	130-Small Fab	S050902
92450A161	Heli-Coil Insert	1 Ea (1 ea)	130-Small Fab	S050700
95327A652	Hex Head Cap Screw	7 Ea (7 ea)	130-Small Fab	S066773
CL-2-C	Lanyard Wire	1 ft (1 ea)	130-Small Fab	S093863
RBEM632V1001101-1	Cap	1 Ea (1 ea)	130-Small Fab	



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S124024



Part: RBEM632V1001101

Job No: 182230

Serial No/Batch: S124024

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 11/02/18

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NOV 9 3 30 PM

NOV 9 3 30 PM

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBEM632V1001101P	1	0	0
130-Small Fab	0502658	1	1	0
	3896T31	2	907	0
	91455A140	7	100	0
	92450A161	1	3	0
	95327A652	7	40	0
	CL-2-C	1	403	0
	RBEM632V1001101-1	1	0	0

Part Specifications

Specifications could not be found.

Plex 8/21/18 8:28 AM dart.Lussier.Patrick



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					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		10/22/18	0.00	0.00	Purchasing		
110	Packaging	1 pcs		10/22/18	0.00	0.00	Packaging2		
120	QC	1 pcs		10/22/18	0.00	0.00	QC6		
130	Small Fab	1 pcs		10/22/18	0.00	0.50	Small Fab-4		
140	QC	1 pcs		10/22/18	0.00	0.00	QC5		
150	Packaging	1 pcs		10/22/18	0.00	0.00	Packaging3-1		
160	QC21-FG	1 Ea		10/22/18	0.00	0.00	QC21		

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Part / Item	Component Name	Quantity	Operation	Container
RBEM632V1001101P	Main Gear Box Sling	1 Ea (1 ea)	100-Purchasing	
0502658	Starpoint VRS w/Star Key	1 Ea (1 ea)	130-Small Fab	
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	130-Small Fab	
91455A140	Flat Washer	7 Ea (7 ea)	130-Small Fab	
92450A161	Heli-Coil Insert	1 Ea (1 ea)	130-Small Fab	
95327A652	Hex Head Cap Screw	7 Ea (7 ea)	130-Small Fab	
CL-2-C	Lanyard Wire	1 ft (1 ea)	130-Small Fab	
RBEM632V1001101-1	Cap	1 Ea (1 ea)	130-Small Fab	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing 130-Small Fab	RBEM632V1001101P	1	0	0
	0502658	1	1	0
	3896T31	2	907	0
	91455A140	7	100	0
	92450A161	1	3	0
	95327A652	7	40	0
	CL-2-C	1	403	0
	RBEM632V1001101-1	1	0	0
Part Specifications				
Specifications could not be found.				

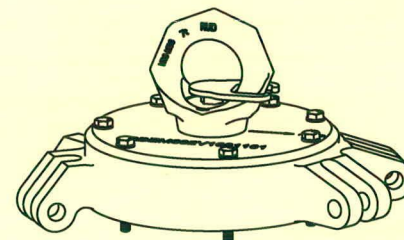
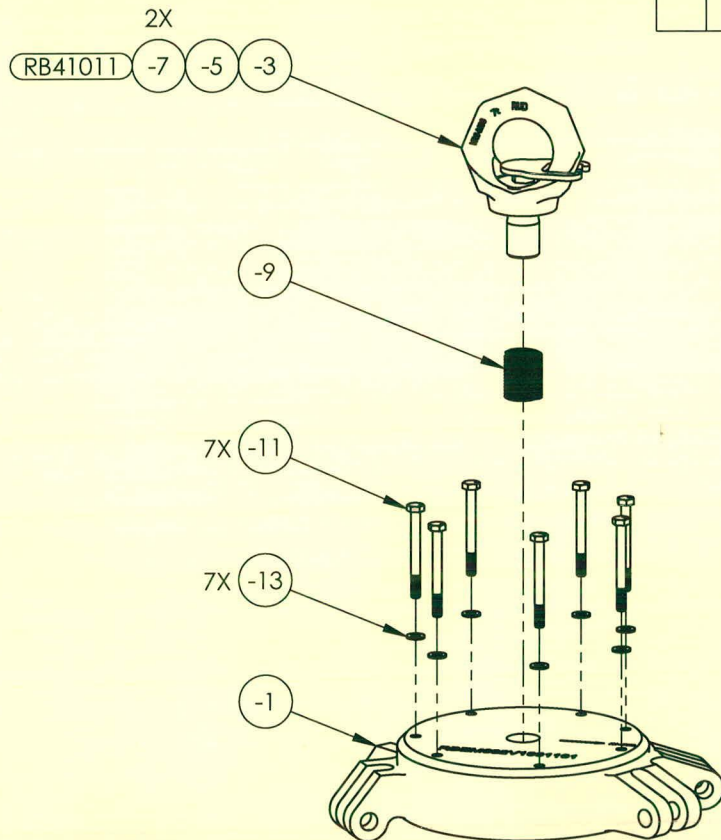
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Order No	Order Date	Customer	Part No	Unit Price	Amount	Quantity Ordered	Customer Due Date	Ship Date	Comments
5743	8/10/2018	CNIGED3	RBEM632V1005102	24595	49190	2	11/2/2018	11/2/2018	Metec with Deviation Note: Metec already has qty 1 in stock built to drawing but without deviation
5743	8/10/2018	CNIGED3	RBEM632V1001101	7650	15300	2	11/2/2018	11/2/2018	qty 1 in stock Need to order additional Arrowtech
5743	8/10/2018	CNIGED3	RBW5305G00131-3G	12670	25340	2	11/2/2018	11/2/2018	Dart but will require slings made by Tulmar
5743	8/10/2018	CNIGED3	RBEM621V1006101	4260	8520	2	11/2/2018	11/2/2018	qty 1 being reworked by Metec
5743	8/10/2018	CNIGED3	RB T102017	9740	9740	1	11/2/2018	11/2/2018	Need to order additional
5743	8/10/2018	CNIGED3	RBW6205G00632-3G	15241	15241	1	11/2/2018	11/2/2018	Metec
5743	8/10/2018	CNIGED3	RBEM623U1002102	2770	11080	4	11/2/2018	11/2/2018	Metec stock delivery 8/20 Dart but need to check straps from Tulmar
5743	8/10/2018	CNIGED3	RBT18588	865	3460	4	11/2/2018	11/2/2018	There is a deviation
5743	8/10/2018	CNIGED3	RB T101753-101	24430	24430	1	11/2/2018	11/2/2018	need drawing
5743	8/10/2018	CNIGED3	RBW7105G00231-3G	8749	8749	1	11/2/2018	11/2/2018	Metec. Drawing ok but needs BOM
5743	8/10/2018	CNIGED3	RBE670-P0001-101	2770	2770	1	11/2/2018	11/2/2018	stock
5743	8/10/2018	CNIGED3	RBE350A91-2381-01	1465	1465	1	11/2/2018	11/2/2018	Dart
5743	8/10/2018	CNIGED3	HT-500-010P-06P	77	385	5	11/2/2018	11/2/2018	Dart
5743	8/10/2018	CNIGED3	RBT18632p	805	805	1	11/2/2018	11/2/2018	stock
5743	8/10/2018	CNIGED3	RBW2905G00132-3G	7823	7823	1	11/2/2018	11/2/2018	stock
5743	8/10/2018	CNIGED3	RB T101543	1985	1985	1	11/2/2018	11/2/2018	Dart

Rob Aboud

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	3/17/2016	RJC	JAG
2	17-0016	-1 CH'D WAS 55° IS 55.002°, WAS 61° IS 60.875°, WAS 61° IS 61.131°, WAS 55° IS 55.002°, WAS 57° IS 56.800°, WAS 41° IS 41.430°, WAS 62° IS 61.520°, WAS 57° IS 57.080°, WAS 42° IS 42.120°, WAS 40° IS 39.590°, WAS 18° IS 17.617°, WAS 4X Ø.785 THRU ALL IS 4X Ø.787 +.002/-0.001 THRU ALL. CH'D FINISH WAS DUAL FINISH ZINC PLATE & PAINT YELLOW IS ANODIZE RED MIL-A-8625F, TYPE 11, CLASS II. CH'D ENGRAVE NOTES WAS MACHINE ENGRAVE T/N FILL WITH INK IS MACHINE ENGRAVE T/N, S/N, "MADE IN USA" FILL WITH WHITE INK, WAS MACHINE ENGRAVE T/N, S/N, "MADE IN USA" FILL WITH WHITE INK, WAS MACHINE ENGRAVE T/N, S/N, "MADE IN USA" FILL WITH WHITE INK. -11 HEX HEAD CAP SCREW ADDED TO BOM QTY 7. -13 FLAT WASHER ADDED TO BOM QTY 7.	1/24/2017	RJC	JAG



NOTES:

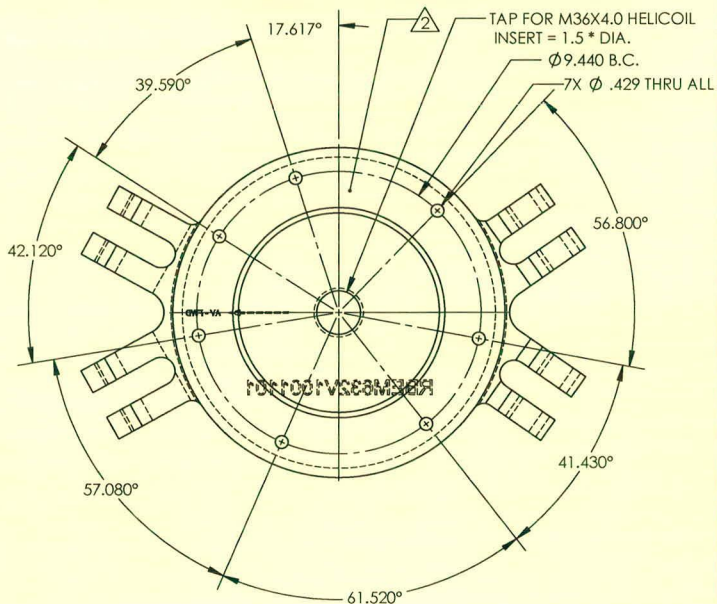
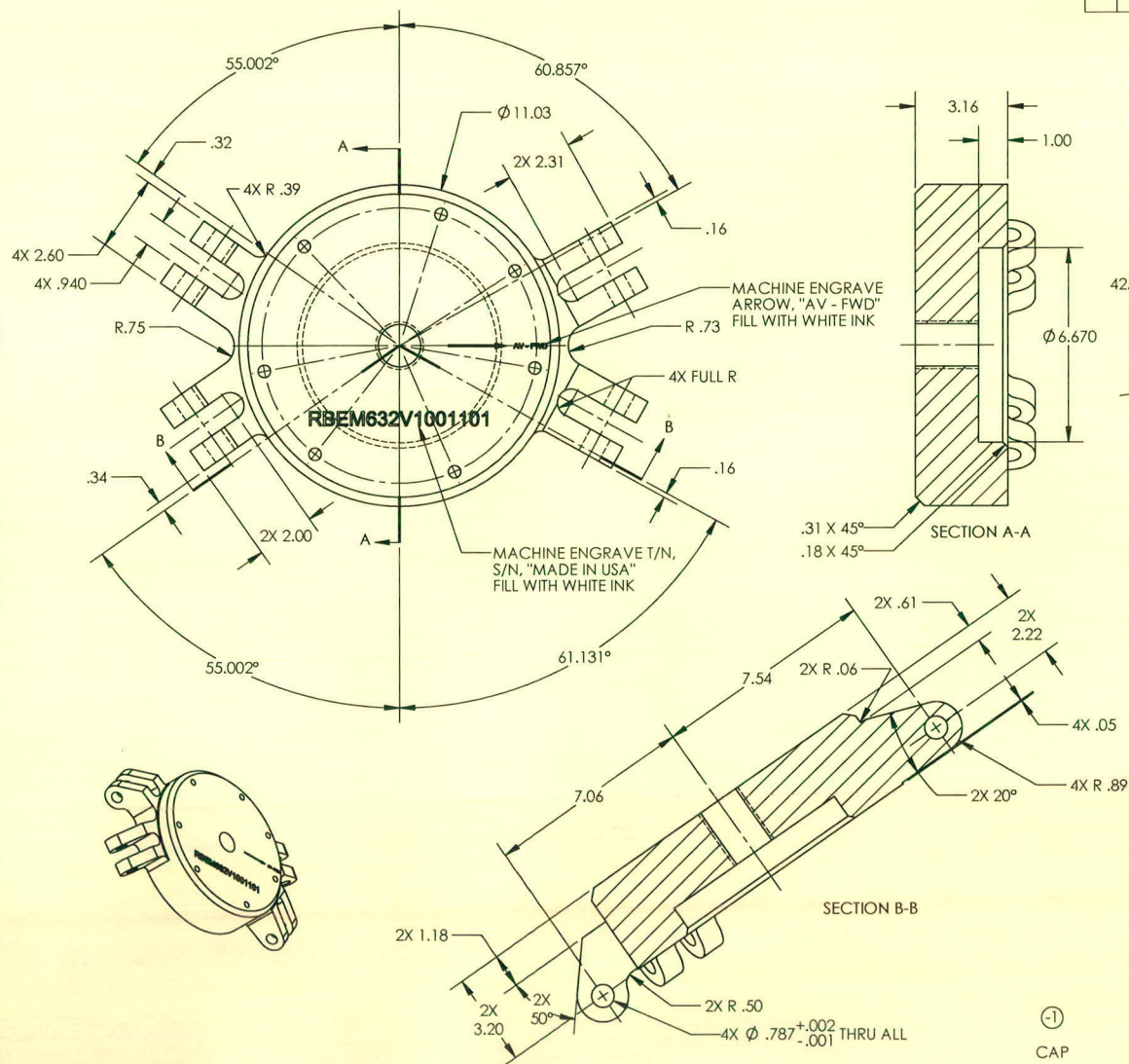
1. REF. AIRBUS T/N: M632V1001101.
2. MAX. LOAD: 13227 LBS/6000 KG.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	CAP	6061		2
		B/O	-3	1	STARPOINT VRS WITH STAR KEY	STEEL	VRS-F-M36 (FASTENAL #0502658)	1
		B/O	-5	1	LANYARD	COATED STEEL	Ø1/16 X 4 (CARR LANE #CL2C)	1
		B/O	-7	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	1
		B/O	-9	1	HELICAL INSERT	S.S.	36 X 4mm X 54mm (WESTERN TOOL & SUPPLY #REC 05363)	1
		B/O	-11	7	HEX HEAD CAP SCREW	STEEL CLASS 10.9	M10 X 1.5mm X 100mm (MCMaster-CARR #95327A652)	1
		B/O	-13	7	FLAT WASHER	STEEL CLASS 10.9	M10 (MCMaster-CARR #91455A140)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1

DART AEROSPACE																	
TITLE MGB SLING																	
DWG NO. RBEM632V1001101	REV 2																
<table border="1"> <tr> <td>MATL</td> <td rowspan="4"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓ </td> </tr> <tr> <td>HEAT TREAT</td> </tr> <tr> <td>FINISH</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> <td rowspan="4"> 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 </td> </tr> <tr> <td>CHECKED: CLOUGH</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> </tr> <tr> <td>QA APPR: LINDSAY</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>USED ON MODEL H175</td> </tr> <tr> <td>SCALE 1:8</td> <td>DATE 12/18/2015</td> </tr> <tr> <td colspan="2" style="text-align: right;">SHEET 1 OF 3</td> </tr> </table>		MATL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓	HEAT TREAT	FINISH	SPEC	DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	CHECKED: CLOUGH	OPPS APPR: ANDERSON	QA APPR: LINDSAY	APPROVED: GILBERT	USED ON MODEL H175	SCALE 1:8	DATE 12/18/2015	SHEET 1 OF 3	
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QA APPR: LINDSAY																	
APPROVED: GILBERT	USED ON MODEL H175																
SCALE 1:8	DATE 12/18/2015																
SHEET 1 OF 3																	

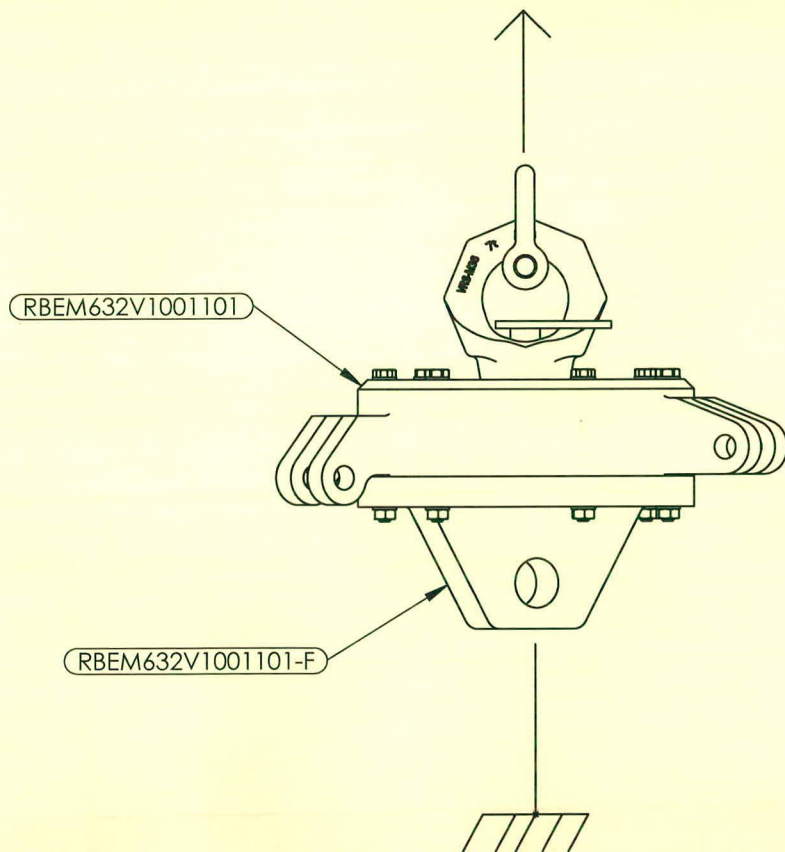
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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	17-00016	-1 CHD WAS 55°S 55.002°, WAS 61°S 60.875°, WAS 61°S 61.131°, WAS 55°S 55.002°, WAS 57°S 56.800°, WAS 41°S 41.430°, WAS 62°S 61.520°, WAS 57°S 57.080°, WAS 42°S 42.120°, WAS 40°S 39.590°, WAS 18°E 7.617°, WAS 43°E 43.785 THRU 44°E 43.787 + 2024.001 THRU 44° CHD FINISH WAS DUAL FINISH ZINC PLATE & PAINT YELLOW S ANODIZE RED MIL-A-8625F, TYPE 11, CLASS II. CHD ENGRAVE NOTES WAS MACHINE ENGRAVE (T/N FILL WITH INK IS MACHINE ENGRAVE T/N, S/N, "MADE IN USA" FILL WITH WHITE INK, WAS MACHINE ENGRAVE ARROW, "AV-FWD" FILL WITH INK IS MACHINE ENGRAVE ARROW, "AV-FWD" FILL WITH WHITE INK.	1/24/2017	RJC	JAG	



		REV	
		2	
TITLE		MGB SLING	
DWG NO.		RBEM632V1001101-1	
MAY 1, 2001		UNLESS OTHERWISE SPECIFIED	
REAR		DIMENSIONS ARE IN INCHES	
FRONT		XXX ± .005 FRACTIONS ± 1/8	
RED ANODIZE		XX ± .01 ANGLES ± 5°	
SPEC MIL-A-8625F, TYPE II, CLASS I		✓ SURFACES ±12°	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES	
CHECKED: CLOUGH		.015 x .45" OR .015"	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
SCALE 1:4		AS SHOWN ON MODEL	
DATE 12/18/2015		H175	
		SHEET 2 OF 3	

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INSPECTION & TESTING PROCEDURES FOR THE
RBEM632V1001101 MGB SLING. INSPECT THIS ASSEMBLY BEFORE
EACH USE.

REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED
OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, ATTACH SLING ASSEMBLY TO
FIXTURE, RBEM632V1001101-F. TORQUE BOLTS 20 LBS/FT.
2. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF
12000kg. / 26,450 LBS.
3. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY
CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
4. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR
STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR: 38 NOV 09 2018
TESTER: Mathieu Kocher
S/N: 5124024
DATE: 11/09/2018

 190 S. Danebo Ave., Eugene, OR. 97402 1-800-556-4166 e-mail: sales@dartaero.com dartaerospace.com		
TITLE MGB SLING		
DWG NO. RBEM632V1001101	REV 2	CUSTOMER 1 OF 1
SCALE 1:6	DATE 1/23/2017	SHEET 3 OF 3



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040784**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO040784
PO Date: 8/20/18
Due Date: 10/22/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		RBEM632V1001101P			Main Gear Box Sling	Firmed	-	10/22/18	1 Ea	0 Ea	1 Ea	\$4,164.83/Ea	\$4,164.83
Grand Total: \$4,164.83													

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER. (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

RECEIVED
8/20/18
G.E.

Plex 8/20/18 2:40 PM dart.Lussier.Patrick

8/20/2018

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040784

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO040784
PO Date: 8/20/18
Due Date: 10/22/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED
AUG 20 2018

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
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w/o 182230													
NOV 02 2018													
Grand Total: \$4,164.83													

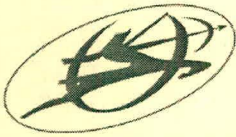
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Procurement Quality Clauses

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- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 8/20/18 2:40 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 302

Date: 10/31/2018
PO Ref: PO# 040784 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
1 ✓
1 ✓

Item
MGB SLING
EXTRA TOOLING

Part No.
RBEM632V1001101 REV 2 ✓

Received by: _____

Packaged by: MS

Checked by: AKB

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:040784 ✓

Dated: 10/31/2018

Our Order / Job No:040784-1AWT

Order Qty:1 ✓

Part Name: MGB SLING

Part Number: RBEM632V1001101 ✓

Lot Size:N/A

Ship Date: 10/31/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: : RBEM632V1001101 ✓

Rev:2

Material Size and Type: -1/6061 ALUM.

Material Specifications: ALUM: ASTM B221

Heat Treatment: N/A

Plating/Finish: RED ANODIZE: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 10/31/18

Signed: Herbert M. Ladd

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

